



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5550-1

Job Sheet 194984



Part No: D5550-1

Job Qty: 1 pcs

Part Name: Fwd Outboard Beam



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/13/19

Job Tracking No:

Due Date: 6/14/19

Created By: Jennifer Renwick

Type: SOLD

Description:

Note: DWG D5550 REV.A SHEETS 3,5 IPP REV:A 17.09.05 NEW ISSUE DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
105	Waterjet - Flow - 1	1 pcs		6/14/19	0.00	1.23	Waterjet - Flow		06/19/05/25
110	QC 2	1 pcs		6/14/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		06/19/05/25
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		
							QC 2 - 5		
							QC 2 - 71		
120	HAAS 4 Axis - B4B	1 pcs		6/14/19	0.00	2.46	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
130	QC 2	1 pcs		6/14/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		

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				QC 2 - 19	
				QC 2 - 2	
				QC 2 - 20	
				QC 2 - 22	
				QC 2 - 23	
				QC 2 - 25	
				QC 2 - 32	
				QC 2 - 33	
				QC 2 - 35	
				QC 2 - 39	
				QC 2 - 4	
				QC 2 - 40	
				QC 2 - 44	
				QC 2 - 45	
				QC 2 - 48	
				QC 2 - 49	
				QC 2 - 50	
				QC 2 - 51	
				QC 2 - 52	
				QC 2 - 57	
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
140	QC 8	1	6/14/19	0.00 0.00	QC 8 - 12
		pcs			QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
					QC 8 - 47
					QC 8 - 40
					QC 8 - 52
					QC 8 - 23
150	Handfinish - 1-1 Chemical-	1	6/14/19	0.00 0.25	Handfinish - 1 - 1 - B4B
	B4B	pcs			Handfinish - 1 - 2 - B4B
					Handfinish - 1 - 3 - B4B
					Handfinish - 1 - 4 - B4B
					Handfinish - 1 - 5 - B4B
					Handfinish - 1 - 6 - B4B
					Handfinish - 1 - 7 - B4B
					Handfinish - 1 - 8 - B4B
					Handfinish - 1 - 9 - B4B
					Handfinish - 1 - 10 - B4B
					Handfinish - 1 - 11 - B4B
					Handfinish - 1 - 12 - B4B
					Handfinish - 1 - 13 - B4B
					Handfinish - 1 - 14 - B4B

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					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
160 QC 7	1 pcs	6/14/19	0.00 0.00		QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	BEB 1906-05
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
170 Powdercoat - 1 White Gl(A)-B4B	1 pcs	6/14/19	0.00 0.09		Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
180 QC 3	1 pcs	6/14/19	0.00 0.00		QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
190 Packaging 3-1 - Stock - B4B	1 pcs	6/14/19	0.00 0.00		QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	

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BR 19-6-6

START: 9:00 OUT: 3:30 FINISH: 9:30

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				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	DAS
				Packaging 3 - 8 - B4B	58
				Packaging 3 - 9 - B4B	9-8 JUN 1 11 2019
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
200 QC 21 - SA	1	6/14/19	0.00 0.00	QC 21 - SA - 21	DAS JUN 1 11 2019
	pcs			QC 21 - SA - 70	21
				QC 21 - SA - 53	9-8

Part Op 105 - ***GRAIN DIRECTION*** 1-Cut contour and pocket as per Dwg Dwg Rev: A Prog Rev: A 2-Debur if

Descriptions: necessary

110 - (QC2- Inspect parts off machine FAI/FAIB)

120 - (HAAS CNC Vertical Machine), Face and Drills holes as per dwg Dwg Rev: _____

130 - (QC2- Inspect parts off machine FAI/FAIB)

140 - (QC8- Inspect parts - second check)

150 - (Chemical Conversion Coat per QSI005 4.1)

160 - (QC7-Inspect Chemical Conversion Coat)

170 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum), ***Mask holes or blow out access powdercoat in holes*** START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____

180 - (QC3- Inspect Part Finish)

190 - (Identify as per dwg & Stock Location: _____)

200 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.000X12.000	6061-T6 Bar 1.00 X 12.00	2.1600 ft (2.16 ea)	105-Waterjet - Flow - 1	S123956

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
105-Waterjet - Flow - 1	M6061T6B1.000X12.000	2	15	0

Part Specifications	
Specifications could not be found.	

Plex 5/13/19 8:43 AM Dart.Renwick.Jennifer



Container No: S184126



Part: D5550-1

Job No: 194984

Serial No/Batch: S184126

Revision: A

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 05/27/19

DART AEROSPACE LTD		Work Order: 194984
Description: Fwd Outboard Beam		Part Number:
Inspection Dwg: D550-1 Rev: A		Page 1 of 1

INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
CNC						
Ø1.25	-0.001 +0.012	Ø1.249	1		UDC-02	
1.75	+/- .030	1.761	1		Tape	
1.93	+/- .030	1.942	1			
3.50	+/- .030	3.514	1			
6.72	+/- .030	6.717	1			
12.72	+/- .030	12.72	1			
1.00	+/- .030	.988	1			
2.00	+/- .030	1.987	1			
Manual Milling						
.735	+/- .010	.738	✓		.738	micronette
.777	+0.005/-0.008	.776	✓		.776	Pin gauge
.191	+0.005/-0.001	.190	✓		.190	Pin gauge
3.600	+/- .010	3.595	✓			Vernier
1.800	+/- .010	1.798	✓			Vernier
.63	+/- .030	.634	✓			Vernier
.60	+/- .030	.603	✓		DAS 64	Vernier
2.300	+/- .010	2.297	✓		9-89	Vernier

Measured by: <i>me</i>	Audited by:	Preliminary Approval:
Date: 19/05/29	Date:	Date:

Rev	Date	Change	Revised by	Approved
A	14.07.14	New Issue	KJ	

M.M.
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